

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 29922C		
Estimate Number	: 10354		
P.O. Number	: N/A	Part Number	: D2322
This Issue	: 12/13/2006 S.O. No. : N/A	Drawing Number	: D2322 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 28791C	Material	: N/A
Written By	: [Signature]	Due Date	: 1/5/2007
Checked & Approved By	: [Signature] 061213	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Job Number:



1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.2132 sf(s)/Unit Total: 4.2630 sf(s)
Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
(M2024T3S.040)
Identify as D2322
Batch: ~~M1024432~~ M10303

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2322
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary

SAO 06:12:28

SAD EG: 12328

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 06:12:28

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Form as per Dwg D2322

SB 07/02/14 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 12322 PAR #: N/A Fault Category: Roll/Fab ^{in Y&S} ~~105~~ NCR: Yes / No DQA: 2 Date: 07/02/21
 QA: N/C Closed: 1 Date: 07.02.21

NCR: <u>29922</u> C		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.11.28	2.0	032 mat'l was used by Human error. Supposed to be .040, Parts scrap.	<u>OSI/12</u>	Scrap: replace parts Ensure to measure the mat'l thickness before using.	<u>SPN</u> <u>06/12/28</u>	<u>OSI/12</u>	<u>OSI/12</u>	<u>06.12.28</u>

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29922C

Part Number: D2322

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-02-10

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-02-19 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-02-19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07-02-19 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-02-19 (20)

Job Completion



07-02-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
BW	CP	DRAWING NO.	D2322	REV. C
CHECKED KE	APPROVED MM	TITLE	STEP SPACER	SHEET 1 OF 1
DATE 98.09.29		SCALE	1:2	
A	94.10.14	NEW ISSUE		
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001		

RELEASED
18.10.08 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
DJS BEFORE MANUFACTURE

OK BP 01/11/09

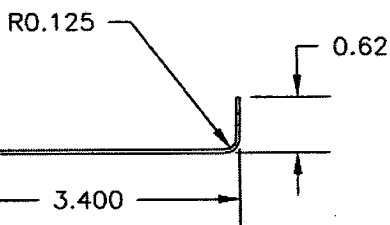
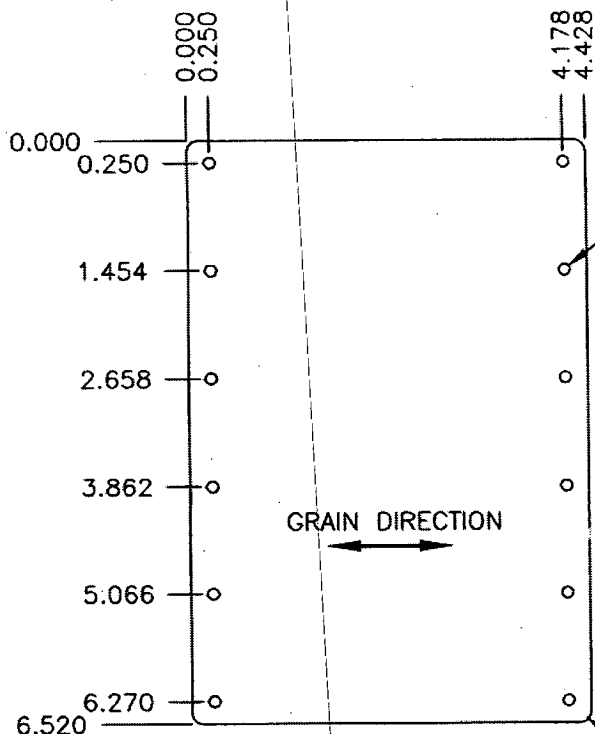
KE 98.05.06

R0.125
(TYP 4 PLACES)

Ø0.128 (TYP 12 PLACES)

GRAIN DIRECTION

FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29922C

